Ship Monday 24/03 Rev E DAS 16 9-89 14/03/26

Work Order ID 115222

March-18-14 11:41:27 AM

115222 ~~PRELIMINARY ISSUE~~ Page 1

D4594-1

B 115222

Item ID:	D4594-1		**Accept**	*N9000040100*	**Setup Start** *NS1*
Revision ID:					**Stop** *NS2*
Item Name:	Plate				
Start Date:	3/18/14	**Start Qty:** ~~8.00~~ 10	~~*8*~~	**Cust Item ID:**	
Required Date:	4/01/14	**Req'd Qty:** ~~8.00~~	~~*8*~~	**Customer:**	
Reference:					**Run Start** *NR1*
Approvals:	**Process Plan:** MCS	**Date:** 14-03-19	**Tooling:**	**Date:**	**Stop** *NR2*
	QC:	**Date:**	**SPC (Y/N):**	**Date:**	

Sequence ID/ Work Center ID	Operation Description	DAS 27 9-89	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4594	**Revision Nbr** ~~PB1~~ M Rev B									
100	FLOW WATER JET	DAS 10 9-89	0.00							
100 Waterjet	**Memo**		0.00				14	0		JM14-03-25
FLOW CNC Waterjet	1-Cut as per Dwg									
	Dwg Rev: PB1									
	Prog Rev: PB1									
	2-Deburr if necessary									
110	QC2- Inspect parts off machine FAI/FAIB		0.00							
110 QC	**Memo**		0.00				14	0		JM14-03-25
Quality Control										

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115222

March-18-14 11:41:27 AM

115222

Item ID: D4594-1
Revision ID:
Item Name: Plate
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 DAS 27 9-89 0.00 14/3/26				14 Inspect as per Dwg PBJ			
140 *140* Brake NC Brake NC	Bend as per dwg NC BRAKE **Memo**	0.00 0.00				14			FF 14-03-25
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 DAS 27 9-89 0.00 14/3/26				14 Inspect as per Dwg PBJ			

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 115222

March-18-14 11:41:27 AM

115222

Item ID: D4594-1
Revision ID:
Item Name: Plate
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00				14	7B	14:3:26	
160 HandFinish Hand Finishing	**Memo**	0.00							
170	QC7-Inspect Chemical Conversion Coat	0.00				14			
170 QC Quality Control	**Memo**	0.00							
180	Identify as per dwg & Stock Location: Sts05	0.00				14			
180 Packaging Packaging	**Memo**	0.00							

DAS 27 9-89
14/3/26

MAR 2 6 2014

DAS 28 9-89

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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General

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☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
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☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
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☐ Misread
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 115222

March-18-14 11:41:27 AM

115222

Item ID: D4594-1
Revision ID:
Item Name: Plate
Start Date: 3/18/14 **Start Qty:** 8.00 *8*
Required Date: 4/01/14 **Req'd Qty:** 8.00 *8*
Reference:

Accept *N9000401100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control									

MLJ 14-03-26

MF 14-3-26

POSITIVE RECALL
EFFECTIVE 4/3/14 AUTH W
RELEASED DAS 16 9-89 DATE 4/4/14

Release Dwg Rev B DAS 27 9-89 Rev 14/3/26

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Countersink
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☐ Drawing
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

March-18-14 11:41:30 AM

Work Order ID: 115222 *115222*

Parent Item: D4594-1 *D4594-1*

Parent Item Name: Plate

Start Date: 3/18/14 **Required Date:** 4/01/14

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP revA 12.01.23 new issue EC verified by:DD
12.02.24 as per dwg reva DD verf:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	410.6032	0.155	2			
M6061T6S.032									**			JM14-0325	
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code	
MAT021	410.60317		
123483	8.57		
m125822	17		
m127272	128.75317		
m128054	256.28		128054

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Inspection Strip in Tube
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☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

DART AEROSPACE LTD	Work Order:	11522
Description:	Part Number:	D4594-1
Inspection Dwg: D4594 Rev: PB1		Page 1 of 1

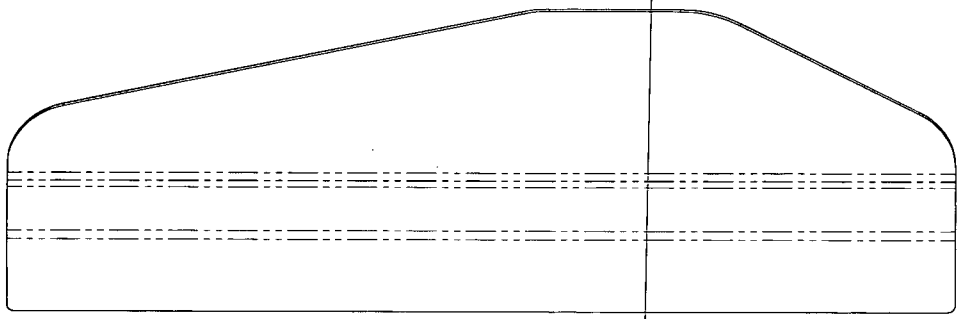
FIRST ARTICLE INSPECTION CHECKLIST

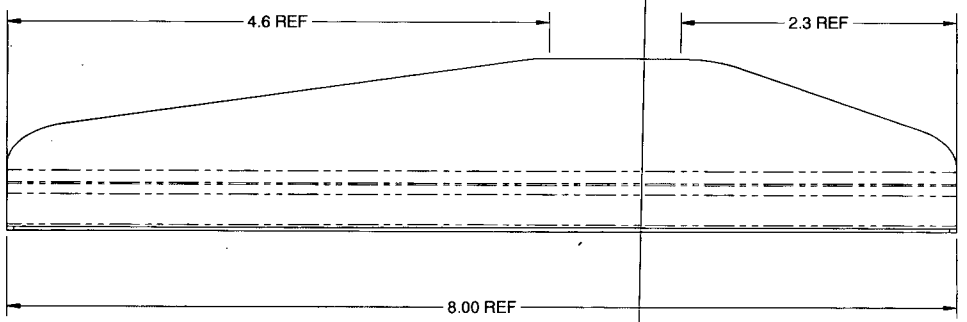
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.93"	+/-0.030"	1.93"	–		V	JKMOS
1.80"	"	1.80"	–		V	
4.45"	"	4.45"	–		V	
5.95"	"	5.95"	–		V	
8.00"	"	8.004"	–		V	
0.032"	+/-0.010"	0.032"	–		V	

Measured by:	JM	Audited by:	SHP	Preliminary Approval:	
Date:	14-03-25	Date:	14/3/25	Date:	

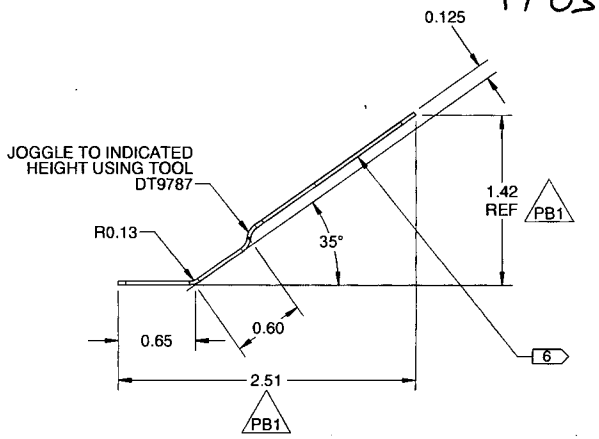
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15





115222 MCS
14-03-19



D4594-1 PLATE

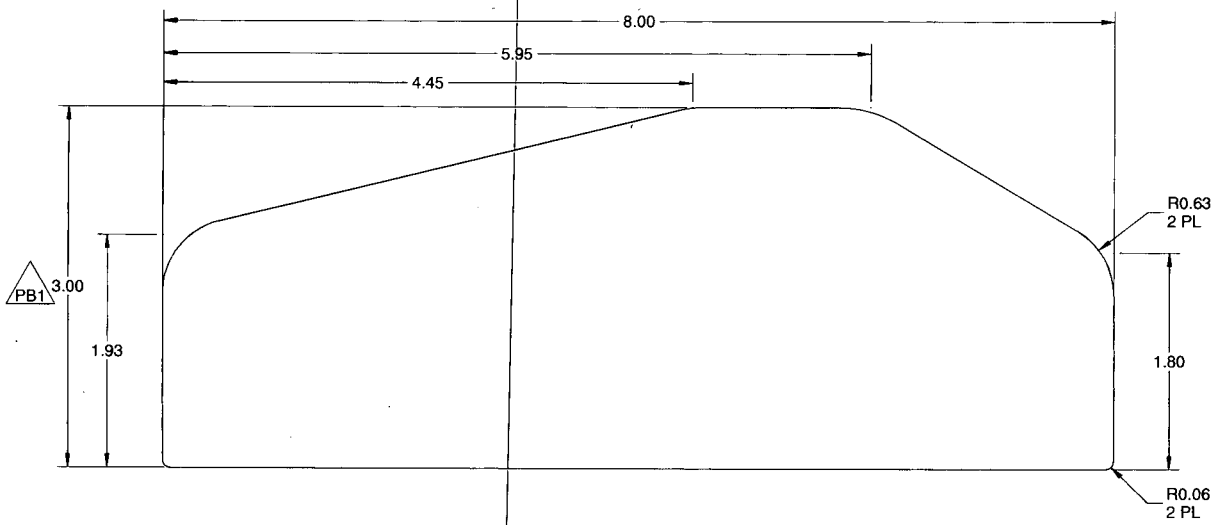
PRELIMINARY B1
AJS 14.03.07

NOTES:
1) MATERIAL: MAKE FROM D4594-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4594-1" AND B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: 0.06 lbs

REV.	DESCRIPTION	BY	DATE
PB1	SHT 2 ZN C7 3.00 DIM WAS 2.71 MULTIPLE DIMENSIONS UPDATED ACCORDINGLY. D4594-1 UPDATED ACCORDINGLY.	AJS	14.03.07
A	NEW ISSUE	CP	12.01.09

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4594	REV. PB1
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE PLATE	SCALE NTS
DE APPR.			
DATE	14.03.07		

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D4594-1F PLATE

PRELIMINARY B1
AJS 14.03.07

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 lbs

DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. PB1
MFG. APPR.		D4594 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		PLATE NTS
DATE	14.03.07	

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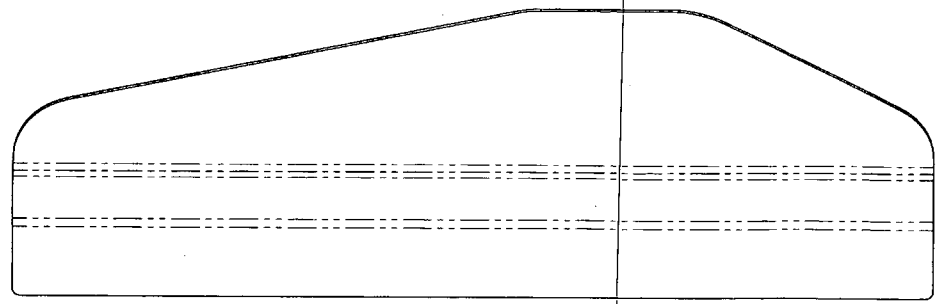
DART AEROSPACE LTD

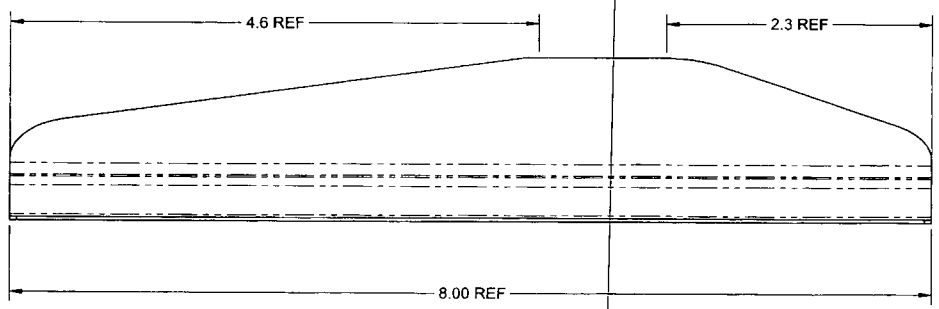
Description: Plate		Work Order:	115227
Inspection Drawing: D4594-1	Rev: PA1	Part Number:	D4594-1

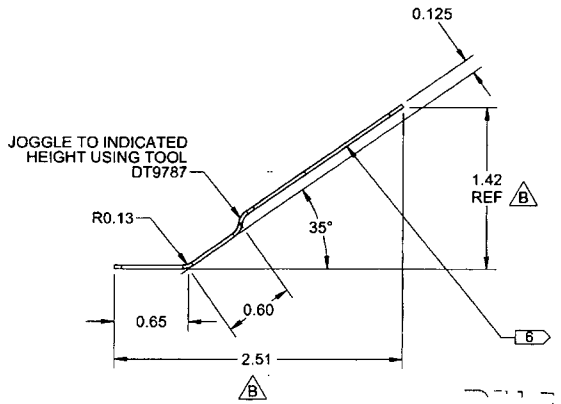
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.65	+/- .030	.654	✓		V	SN - 11
.60	+/- .030	.588	✓		V	SN - 11
1.42	+/- .020	1.4	✓		V	SN - 11
35°	+/- ½°	35°	✓		Protractor	SN - 7

Measured by: DAS 30 9-89	Checked By: FF	QC inspector: DAS 27 9-89	Engineering Approval (*if necessa*
Date 14/03/27	Date 14-03-26	Date 14/3/26	Date







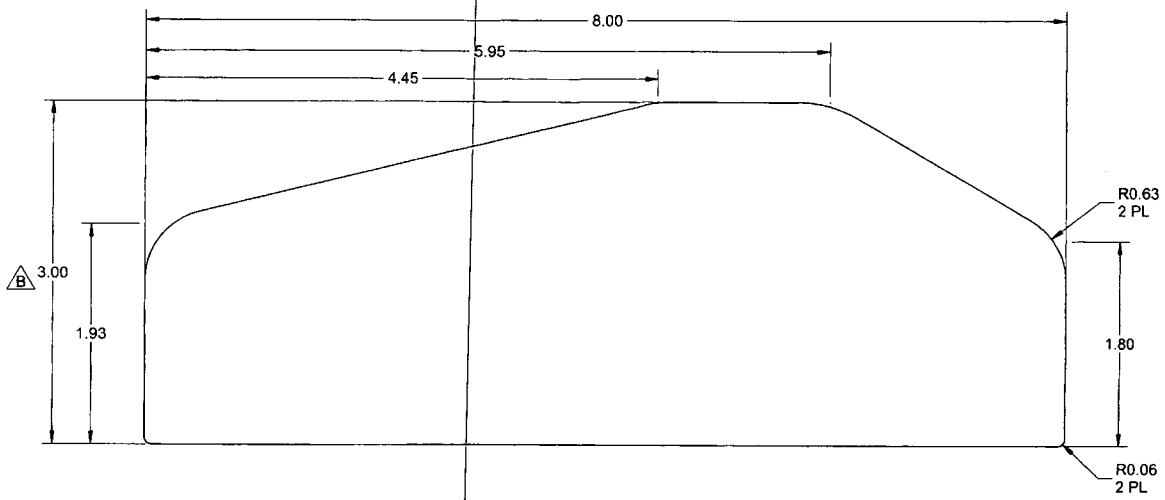
D4594-1 PLATE

NOTES:
1) MATERIAL: MAKE FROM D4594-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4594-1" AND B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
7) WEIGHT: 0.06 lbs

REV.	DESCRIPTION	BY	DATE
B	SHT 2 ZN C7 3.00 DIM WAS 2.71 MULTIPLE DIMENSIONS UPDATED ACCORDINGLY. D4594-1 UPDATED ACCORDINGLY.	AJS	14.03.07
A	NEW ISSUE	CP	12.01.09

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4594	REV. B
MFG. APPR.			SHEET 1 OF 2
APPROVED		TITLE PLATE	SCALE NTS
DE APPR.			
DATE	14.03.07		

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D4594-1F PLATE

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 lbs

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4594	REV. B
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE PLATE	SCALE NTS
DE APPR.			
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